

Work Order ID 64091

Wednesday, November 24, 2010 8:51:15 AM

Page 1

Item ID: D2666-2

Accept

Revision ID:

Item Name: Saddle, RH Fwd Aft In 206

Start Date: 11/24/2010 Start Qty: 4.00

Required Date: 12/16/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date: 10-11-24 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2666	Rev D								

100

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet ☐ 6

B.A 11/01/05

4

0

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

B.A 11/01/05

4

0

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B.A 11/01/05

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 64091

Wednesday, November 24, 2010 8:51:15 AM

Page 2

Item ID:	D2666-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle, RH Fwd Aft In 206					
Start Date:	11/24/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	12/16/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 2 11/01/11 0.00				(4)			
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	4	20	11/01/12
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M15951 Memo START TIME 9:00 FINISH TIME 9:30	0.00 0.00							14 152 11-01-13.

COVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64091

Wednesday, November 24, 2010 8:51:15 AM

Page 3

Item ID: D2666-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, RH Fwd Aft In 206

Start Date: 11/24/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

4 d M 11/26/13

170

Identify as per dwg & Stock Location: 426

0.00

Packaging

Memo

0.00

Packaging

11/26/14 G

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/01/14 JF

L. L. L. L.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 24, 2010 8:51:20 AM

Page 1

Work Order ID: 64091



Parent Item: D2666-2



Parent Item Name: Saddle, RH Fwd Aft In 206

Start Date: 11/24/2010

Required Date: 12/16/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	62.0000	1	4			

Saddle Billet

Location

Loc Qty

Loc Code

MAT40

62

61385

2

✓ 63537

60

4.0

B.A 11/01/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 64091
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. D	Page 1 of 1

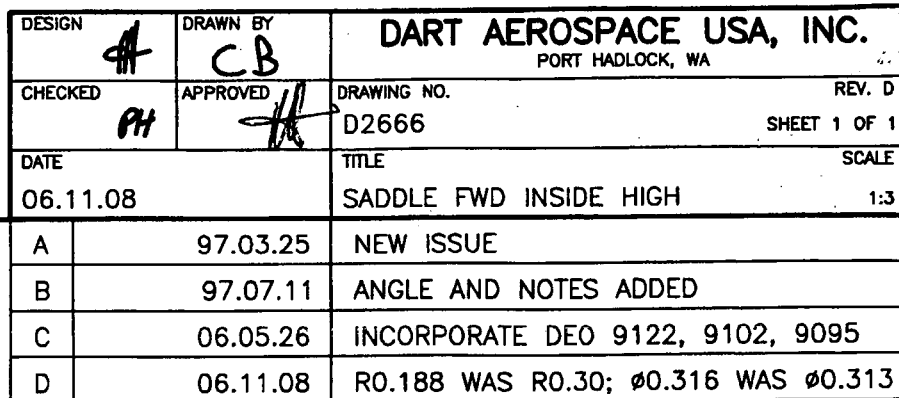
Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.123	0.124	0.125	0.122	Mic	11B-120
B	0.100	0.140		0.111	0.111	0.111	0.111	"	"
C	2.470	2.510		2.493	2.493	2.493	2.493	Vern	GA-01
D	0.100	0.180		0.125	0.125	0.125	0.125	"	"
E	0.210	0.230		0.225	0.225	0.225	0.225	"	"
F	1.313	1.343		1.327	1.327	1.327	1.327	H-6	31006
G	0.240	0.260		0.255	0.255	0.255	0.255	Vern	GA-01
H	0.615	0.685		0.645	0.645	0.645	0.645	"	"
I	1.125	1.145		1.1345	1.1343	1.1342	1.135	Dial	HAAS3
J	0.990	1.010		1.000	1.000	1.000	1.000	Vern	GA-01
K	0.235	0.240		0.237	0.237	0.237	0.237	"	"
L	0.510	0.515		0.510	0.510	0.510	0.510	"	"
M	0.100	0.120		0.110	0.110	0.110	0.110	D-6	GA-08
N	1.565	1.585		1.5748	1.5745	1.5747	1.5742	Dial	HAAS3
O	5.990	6.010		6.000	6.000	6.000	6.000	Vern	GA-01
P	1.245	1.255		1.250	1.250	1.250	1.250	"	"
Q	2.495	2.505		2.500	2.500	2.500	2.500	"	"
R	0.490	0.510		0.500	0.501	0.501	0.502	"	"
S	0.313	0.318		0.314	0.314	0.314	0.314	"	"
T	2.495	2.505		2.500	2.500	2.500	2.500	"	"
U	1.357	1.367		1.362	1.362	1.362	1.362	"	"
V	0.315	0.322		0.317	0.317	0.317	0.317	"	"
W	0.540	0.560		0.550	0.551	0.551	0.552	"	"
X	1.674	1.684		1.679	1.679	1.679	1.679	"	"
Y	0.257	0.262		0.259	0.259	0.259	0.259	"	"
Z	0.178	0.198		0.188	0.188	0.188	0.188	R-6	ref.
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: BA
Date: 11/01/05

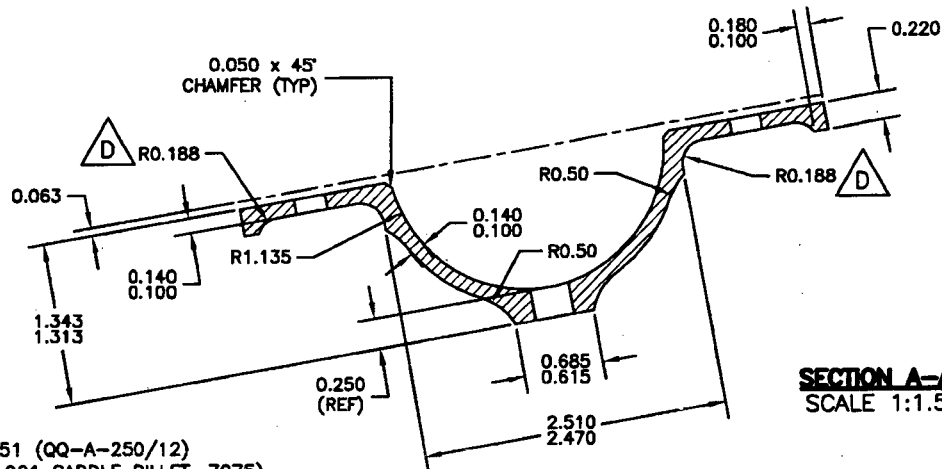
Audited by: SL
Date: 11/01/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



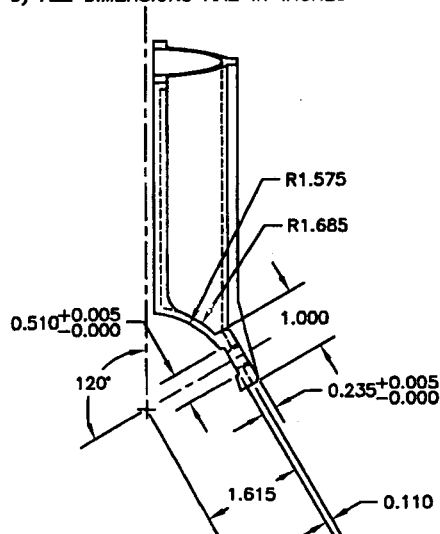
07.02.12 ~~11~~

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44091

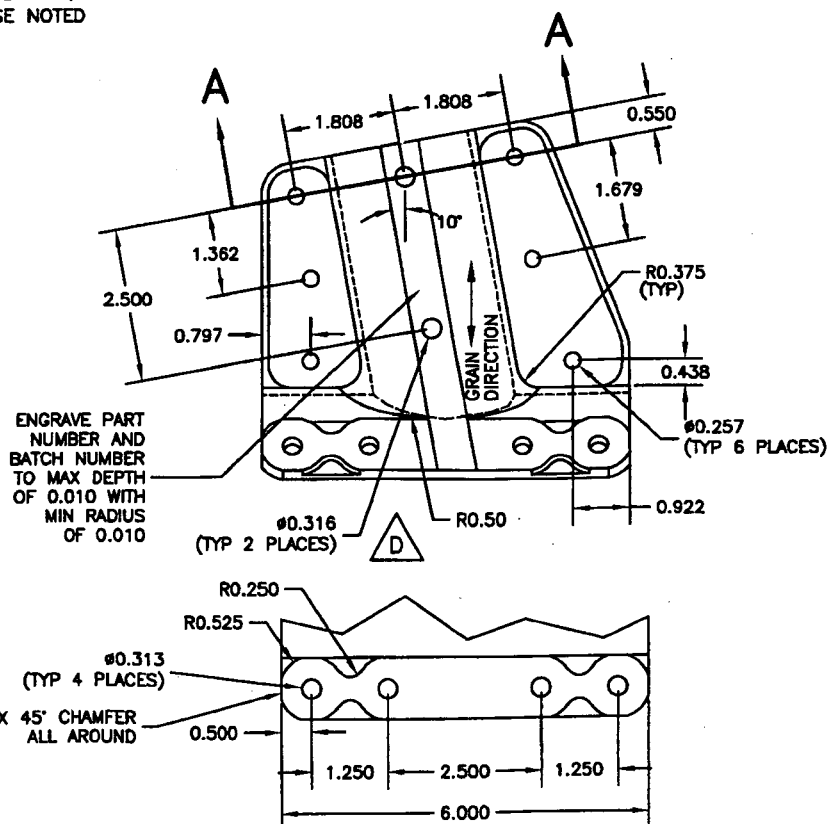


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



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